



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBW6405G08632-3G

Job Sheet 173620



Part No: RBW6405G08632-3G

Job Qty: 1 pcs

Part Name: AW139 Tail Rotor Bushing Removal/Install



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/6/18

Job Tracking No:

Due Date: 4/2/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Ship Via:

Rev B

DAS
03
9-89

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	4/2/18	4/2/18	0.00	0.00	Start Up Small Fab-4		MLC
110	Small Fab	1 pcs	4/2/18	4/2/18	0.00	0.00	Small Fab-8		MLC DAS
120	QC	1 pcs	4/2/18	4/2/18	0.00	0.00	QC4		DAS 38 9-89
130	Packaging	1 pcs	4/2/18	4/2/18	0.00	0.00	Packaging3-1		DAS 58 9-89
140	QC	1 pcs	4/2/18	4/2/18	0.00	0.00	QC21		9-89

Part Op 90 - ***See engineering for placard sign off***
Descriptions:

DAS
21

MAY 04 2018

MAY 04 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
APP-1200-E	Case ✓	1 Ea (1 ea)	90-Start up Operation	
RB41011	Dart Tooling Placard, Aluminum ✓	1 Ea (1 ea)	90-Start up Operation	
93 RBW6405G08632-3G-07	Bottom Tool Protector (Y-20, Black)	1 Ea (1 ea)	90-Start up Operation	
93 RBW6405G08632-3G-09	Top Tool Protector (Y-20, Black)	1 Ea (1 ea)	90-Start up Operation	
99 RBW6405G08632-3G-13	Inside Placard (Lasered) ✓	1 Ea (1 ea)	90-Start up Operation	
RBW6405G08732-3G	Tail Rotor Bushing Removal Tool ✓	1 Ea (1 ea)	90-Start up Operation	
97 RBW6405G08832-3G	Tail Rotor Bushing Install Tool ✓	1 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	APP-1200-E	1	1	0
	RB41011	1	944	0
	RBW6405G08632-3G-07✓	1	0	0
	RBW6405G08632-3G-09✓	1	0	0
	RBW6405G08632-3G-13	1	0	0
	RBW6405G08732-3G	1	0	0
	RBW6405G08832-3G	1	0	0

Part Specifications

Specifications could not be found.



Container No: S068092



Part: RBW6405G08632 - 3G

Job No: 173620

Serial No/Batch: S068092

Revision: B

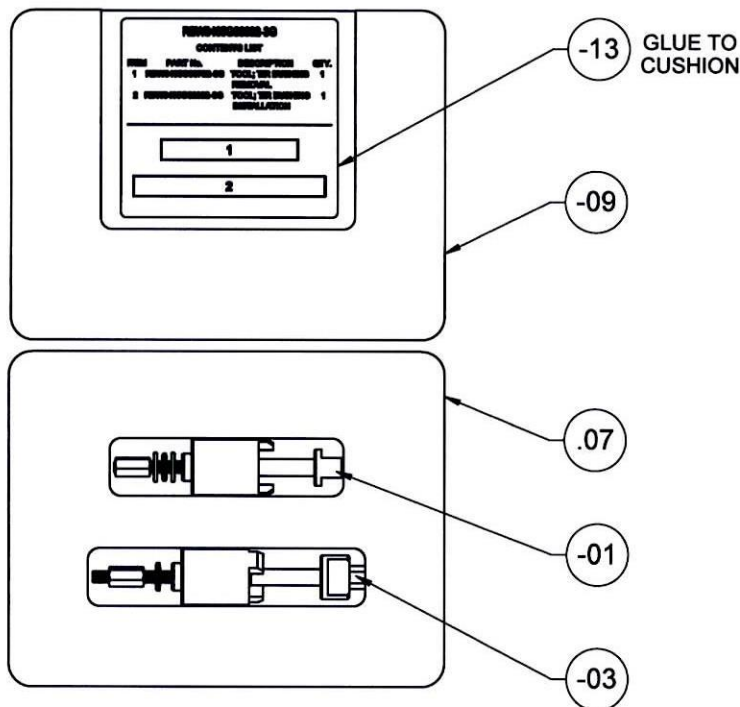
Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 05/03/18

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REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	SEPERATED OUT FROM KIT	3/14/11	JAG	RW
B	-13 CH'D LETTERING COLOR WAS ALUMINUM IS WHITE. CH'D MATERIAL IN BOM WAS ALUMINUM IS PLASTIC. -9 CH'D MATERIAL WAS EPDM IS Y-20, BLACK.	3/12/13	BIM	RJC



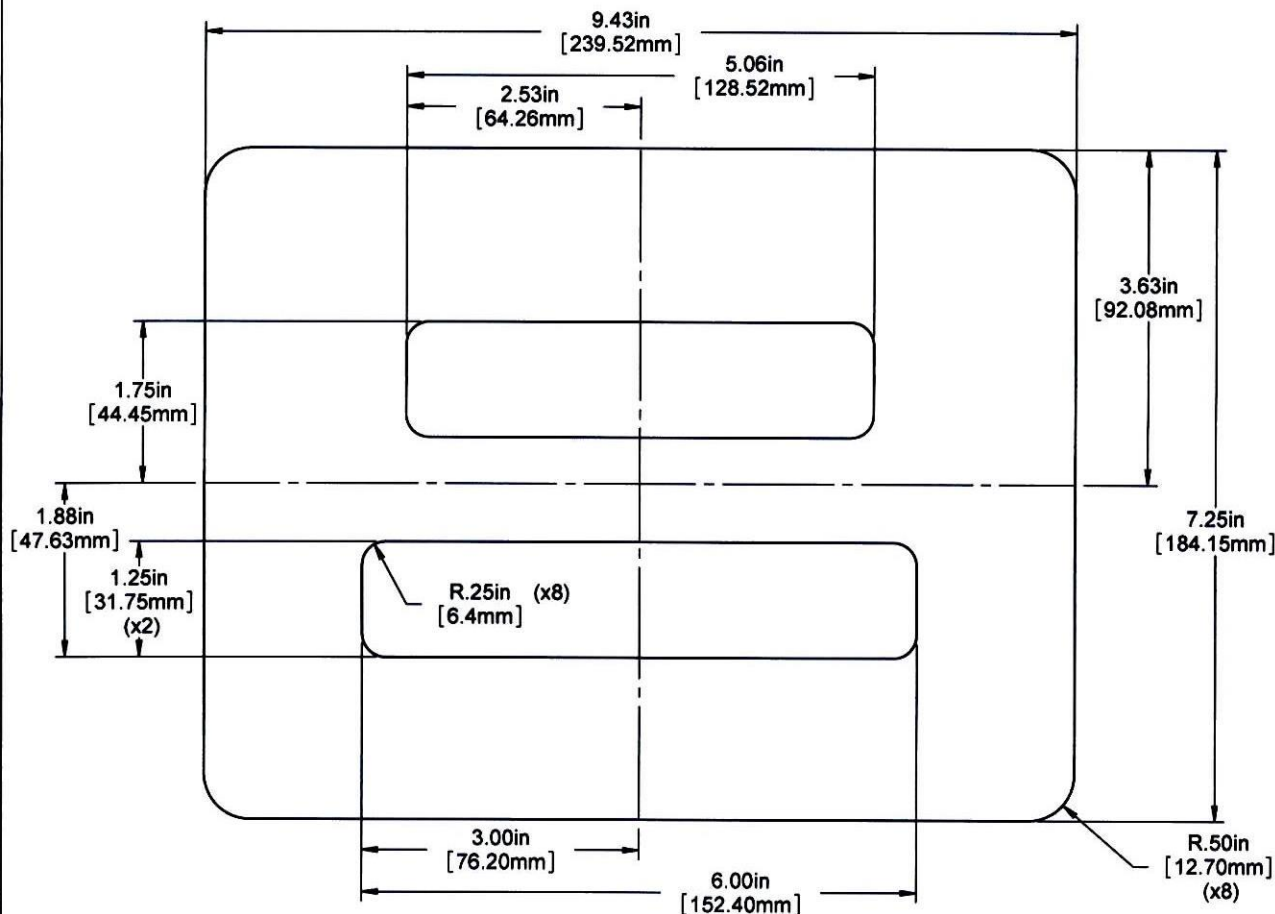
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 173620 *um*
MAR 06 2018

B/O	PART #	QTY	DESCRIPTION	MATERIAL	B/O INFORMATION	Pg
	-01	1	T/R BUSHING REMOVAL TOOL		T/N RBW6405G08732-3G	1
	-03	1	T/R BUSHING INSTALL TOOL		T/N RBW6405G08832-3G	1
B/O	-05	1	HARD CASE	PLASTIC	PELICAN #280P-1200-E	N/S
B/O	-07	1	BOTTOM TOOL PROTECTOR	Y-20; BLACK	3 x 7-1/4 x 9-1/2 I.R. SPECIALTIES	2
B/O	-09	1	TOP TOOL PROTECTOR	Y-20, BLACK	1-3/16 x 7-1/4 x 9-1/2 I.R. SPECIALTIES	3
B/O	-11	1	RB PLACARD, (on case top)	ALUMINUM	RB41009	N/S
B/O	-13	1	INSIDE PLACARD, (lasered)	PLASTIC	1/32 x 4-5/16 x 4-11/16	4

		RED BARN MACHINE	
		TITLE TAIL ROTOR BUSHING KIT	
DWG NO.		REV	
RBW6405G08632-3G		B	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: PERRITT	
TOLERANCES ON:		APPROVED	
DECIMALS .XXX ± .005		HEAT TREAT	
XX ± .01		FINISH SPEC	
X ± .1		USED ON MODEL	
UNLESS OTHERWISE SPECIFIED 1 BREAK ALL SHARP EDGES 015 x 45° PR 015 R		AGUSTA	
2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE	DATE	SHEET	
NTS	8-24-10	1 of 4	

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
-	--	-	-



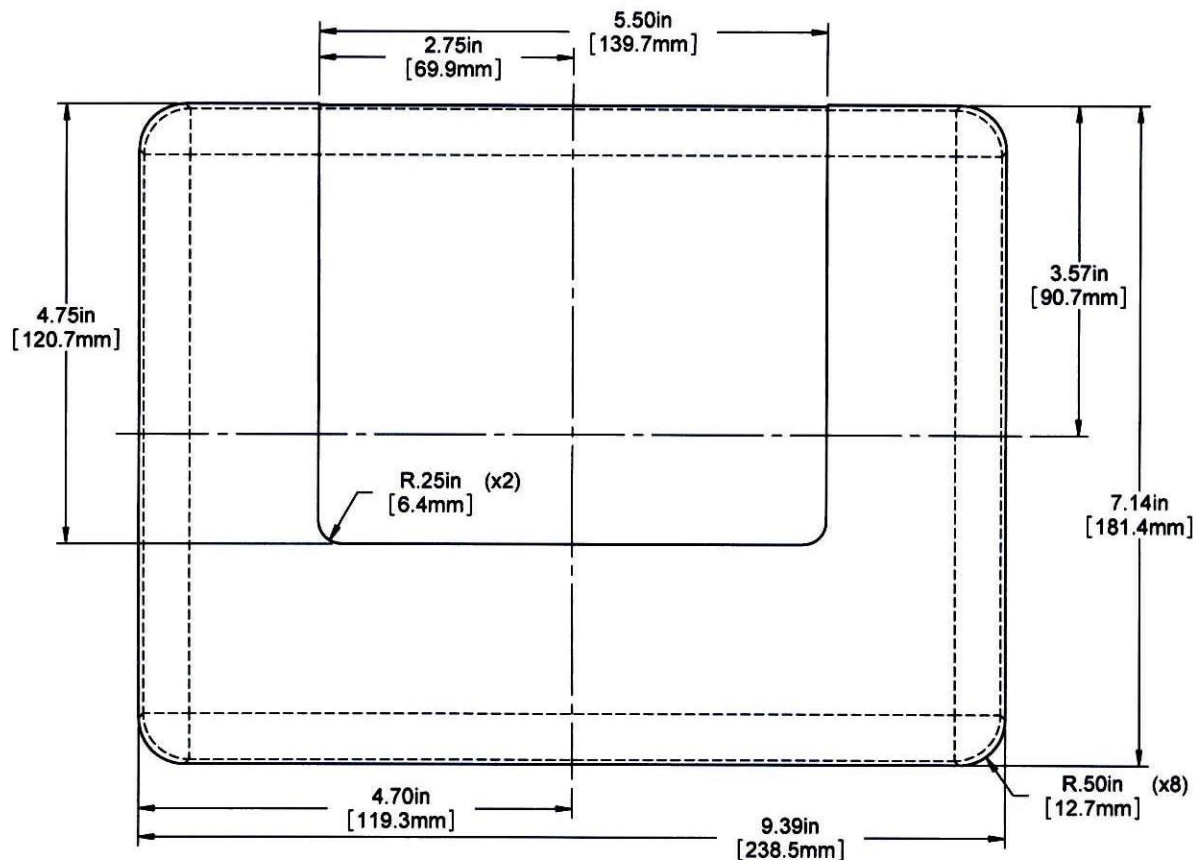
-07

BOTTOM TOOL
CUSHION

RED BARN MACHINE	
TITLE TAIL ROTOR BUSHING KIT; PARTS	
DWG NO RBW6405G08632-3G-07	REV B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .005 FRACTIONS 1/32 ANGLES ± 5°	
DRAWN BY PERRITT	
APPROVED	
HEAT TREAT	
FINISH SPEC	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 x 45° PR 015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 8-24-10
SHEET 2 of 4	

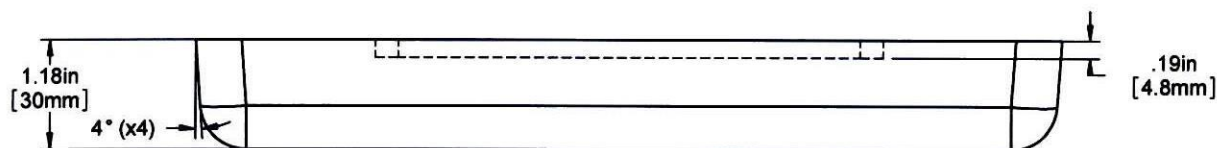
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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
-	-	-	-



-09

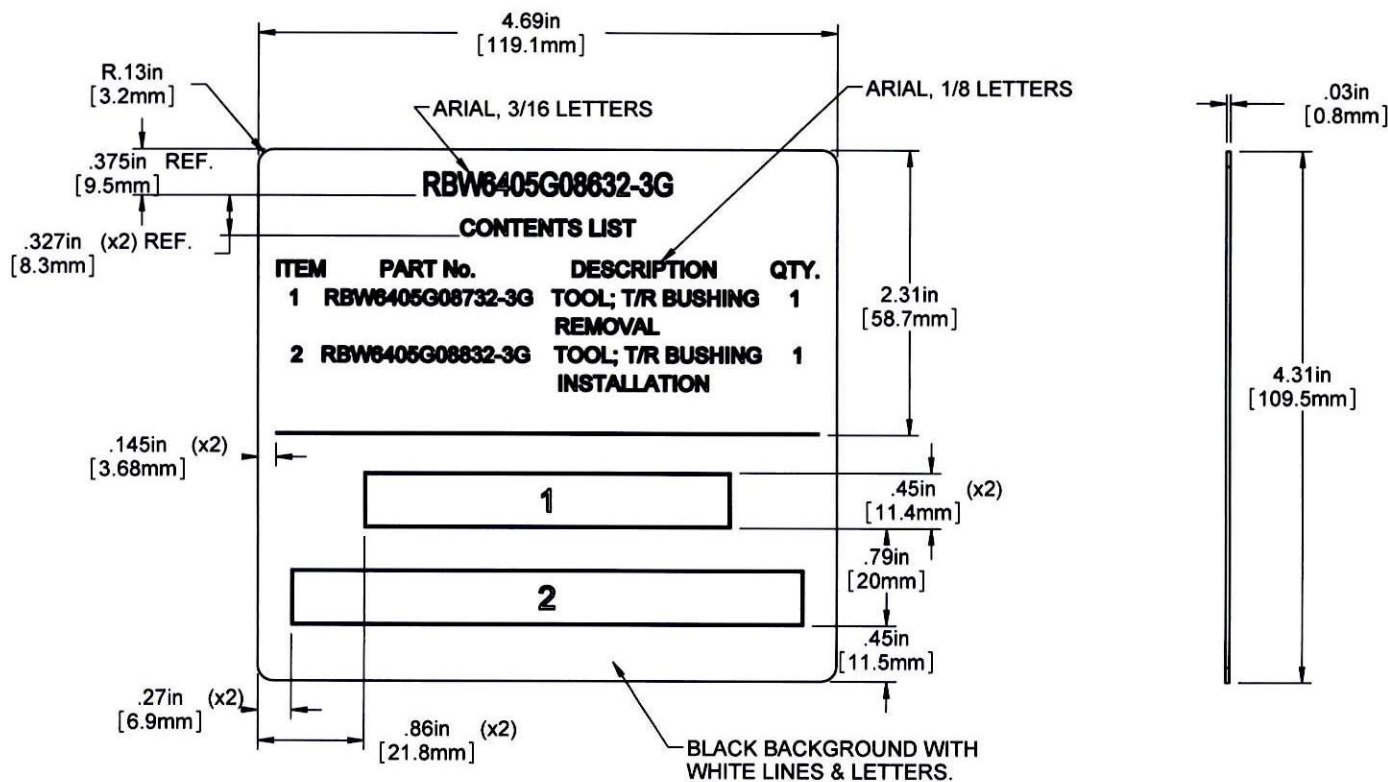
TOP TOOL
CUSHION



RED BARN MACHINE	
TITLE TAIL ROTOR BUSHING KIT; PARTS	
DWG NO. RBW6405G08632-3G-09	REV B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON:	DRAWN BY PERRITT
DECIMALS XXX ± .005	APPROVED
METRIC X ± .1mm	HEAT TREAT
FRACTIONS ± 1/32	FINISH SPEC
ANGLES ± 5°	USED ON MODEL
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES 015 ± 45° PR 015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	AGUSTA
SCALE NTS	DATE 8-24-10
SHEET 3 of 4	

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REVISIONS			
REV	DESCRIPTION	DATE	INITIAL
B	-13 CH'D LETTERING COLOR WAS ALUMINUM IS WHITE.	3/12/13	BIM
			RJC



(-13)

INSIDE PLACARD
LAZER ETCHED

 RED BARN MACHINE	
TITLE TAIL ROTOR BUSHING KIT; PARTS	
DWG NO. RBW6405G08632-3G-13	REV B
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON DECIMALS XXX ± .005 XX ± .01 X ± .1	METRIC X ± 1mm FRACTIONS ± 1/32 ANGLES ± 5°
UNLESS OTHERWISE SPECIFIED 1 BREAK ALL SHARP EDGES 015 x 45° PR 015 R 2 DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 8-24-10
SHEET 4 of 4	
DRAWN BY PERRITT	
APPROVED	
HEAT TREAT	
FINISH SPEC	
USED ON MODEL AGUSTA	